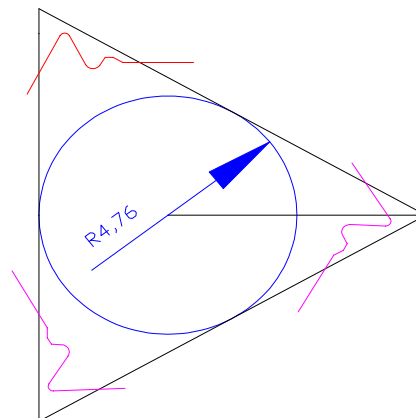









Thread Insert ID 9.525

A8-200-thread-m3

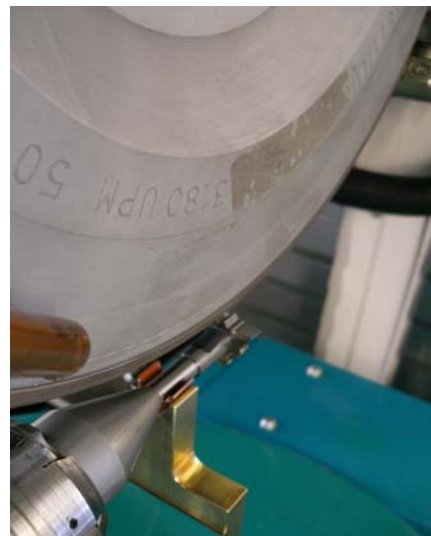
The Thread Insert are completely ground in one setup, including chipbreaker, using the Precision Pin Clamping system. A preliminary probing operations evaluates the orientation of the insert. The Profileoperations are based on VSW-Profilegrinding of our Quinto DXQ, where on most of the parts of the profile the flat sides of the V-Shaped wheel are touching the profile. It leads to a minimal wear of the large grinding wheels.



1. Cycletime for Production

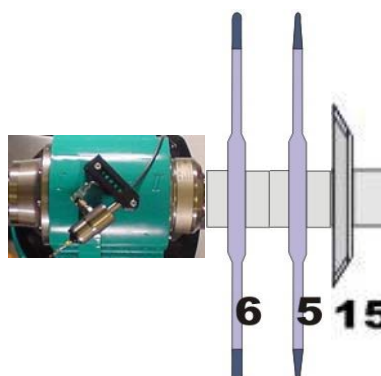
Tool specifications				
Diameter 12 mm, Z 3, Length of cutting edge 5 mm				
Material HM				
Operations				
Feed [mm/Min]	2000	120	120	170
Power [kW]		1	1	1
Cutting feed [m/s]		24	24	24
Used wheels				
Grinding time [s]	19	60	75	60
Total cycle time	3 Min 34			

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.



2. Used Grinding Wheels

15 Ø125 1V1 D64
5 Ø300 14EE1 VSW D76
6 Ø300 14EE1 VSW D46



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : SIRIUS HPM, Precision Pin Clamping, S1 L 650
Control: Fanuc 160i
Coolant: Synthetic Oil, pressure 6 - 7 bar
Software: Quinto 4.2, DXQ

responsible engineer: OP,4.4.07

www.schneeberger.ch

J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland

Subsidiaries in: France, Deutschland, Italia, United States, UK, China